

Work Order ID 61234

August 11, 2010 11:11:21 AM



Page 1

Item ID: D4149-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Stud

Start Date: 8/11/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/8/11 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4149 | B | | | | | | | | |

100

0.00



Doosan

Memo

0.00

Doosan Lathe

turn as per dwg and folio FA950
DWG REV: B
FOLIO REV: AA

SL 10/08/12

10

Ø

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/08/12

10

Ø

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 61234

August 11, 2010 11:11:21 AM



Page 2

Item ID: D4149-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Stud

Start Date: 8/11/10

Start Qty: 10.00



Cust Item ID:

Required Date: 8/25/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

H.A 10/08/14

10

0

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 123

0.00



Packaging

Memo

0.00

Packaging

10/11/10

100 SP

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/16

CL 10/8/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

August 11, 2010 11:11:20 AM

Page 1

Work Order ID: 61234



Parent Item: D4149-5



Parent Item Name: Eyebolt Stud

Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M303R1-000- | | Purchased | No | | | | f | 4.0560 | 0.25 | 2.631579 | | | |



303 Round Bar T.00

Location

Loc Qty

Loc Code

MAT028

4.056

113325

4.056

304 R1.000
This Batch
Only
From 10.08.13

not removed 109541

2.64

2L 10/08/12

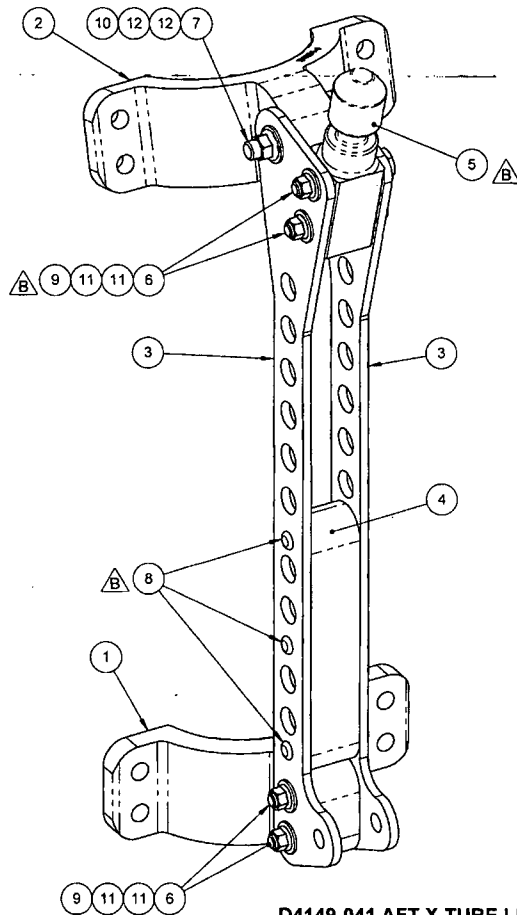
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.17 lbs.

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| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|----------------------|
| | X | D4149-041 | AFT X-TUBE LUG ASSY |
| 1 | 1 | D3910-1 | X-TUBE LUG |
| 2 | 1 | D4091-1 | MOUNTING LUG |
| 3 | 2 | D4149-1 | AFT X-TUBE LUG PLATE |
| 4 | 1 | D4149-3 | SPACER |
| 5 | 1 | D4149-5 | EYEBOLT STUD |
| 6 | 4 | AN3C12A | |
| 7 | 1 | AN4C13A | BOLT |
| 8 | 3 | MS20615-4M18 | RIVET |
| 9 | 4 | MS21043-3 | NUT |
| 10 | 1 | MS21043-4 | NUT |
| 11 | 8 | NAS1149C0332R | WASHER |
| 12 | 2 | NAS1149C0432R | WASHER |

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| | | | |
|------------|---|----|----------|
| B | MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2). ADDED D4149-5 (SHT 5). D4149-5 WAS D3909-5 (ZN D3-1 & D7-2). REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B9-2). REPLACES Ø0.129 3 PL (ZN D8-3). REASON: SEE TR-D350-607-2 REV. B. | MB | 10.07.05 |
| A | NEW ISSUE | MB | 10.06.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.07.05 | | |

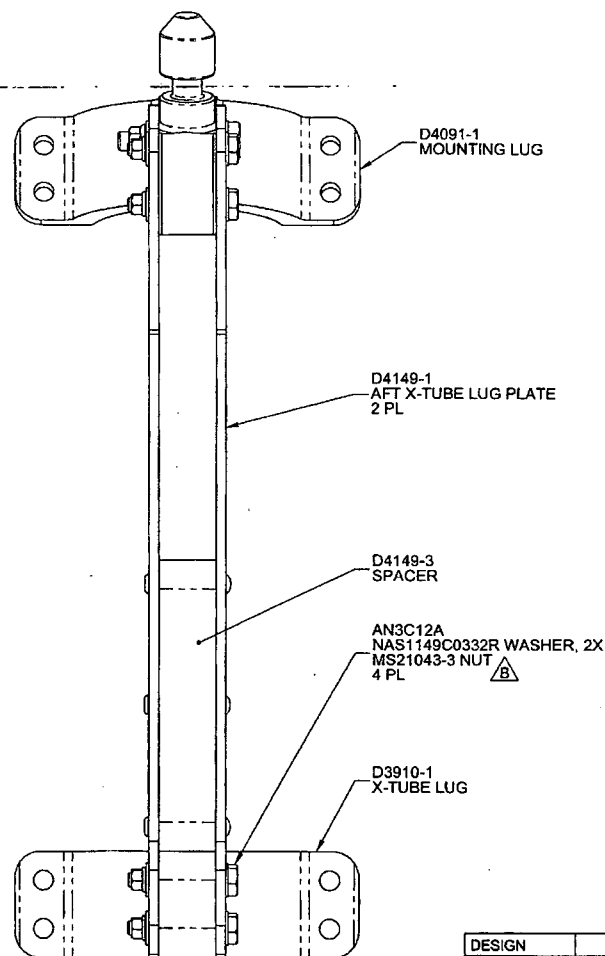
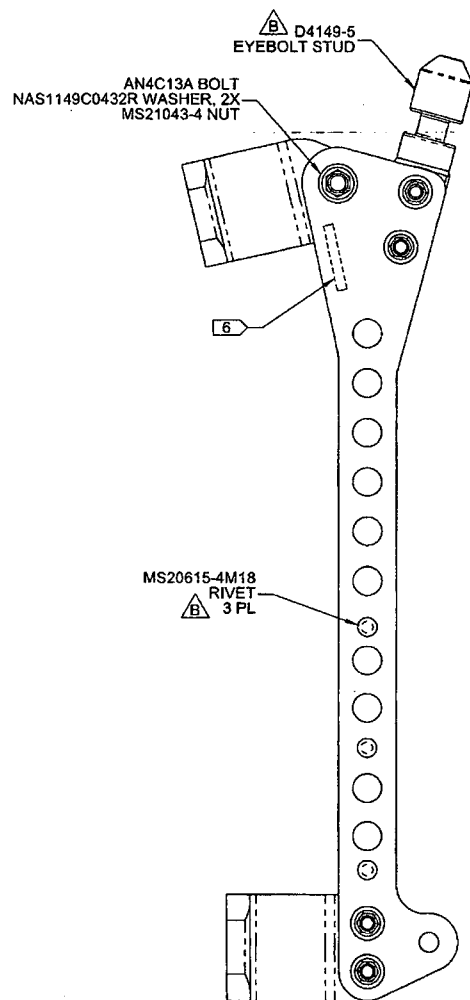
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4149** REV. B
SHEET 1 OF 5

TITLE **AFT X-TUBE LUG ASSY** SCALE NTS

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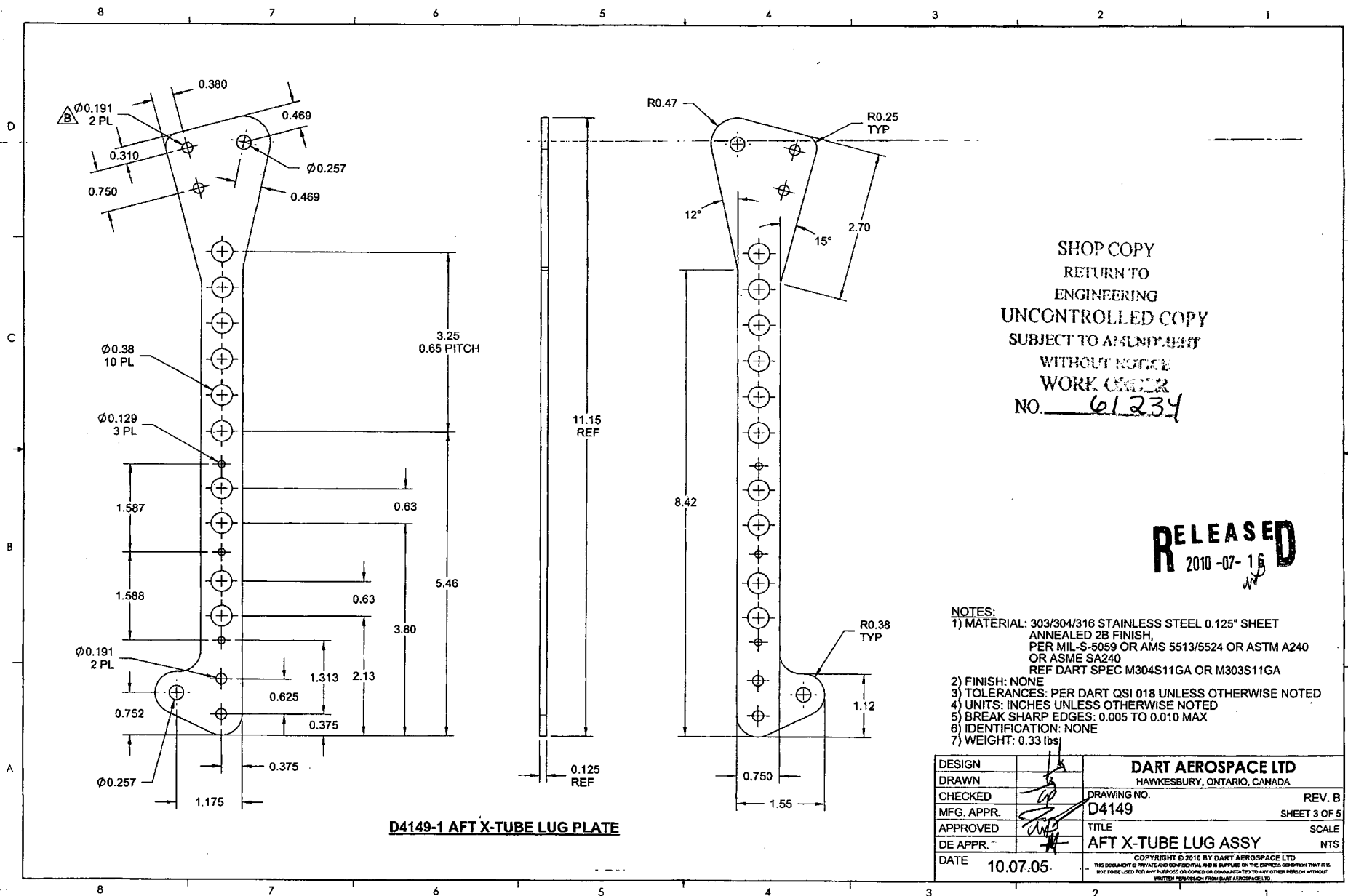
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D4149-041 AFT X-TUBE LUG ASSY

| | | | |
|------------|----------|---|--------------|
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| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4149 | SHEET 2 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | AFT X-TUBE LUG ASSY | NTS |
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8 7 6 5 4 3 2 1

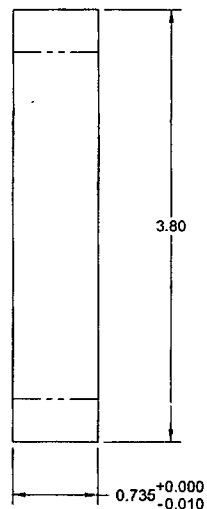
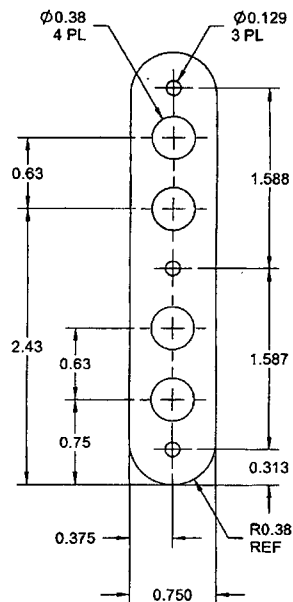


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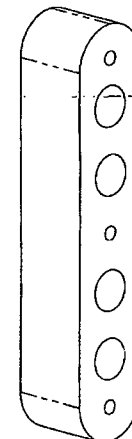
- NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET
ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240
OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.33 lbs

| | | | |
|------------|-----------------|---|--------------|
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4149 | SHEET 3 OF 5 |
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D4149-3 SPACER

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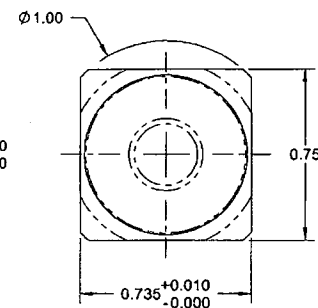
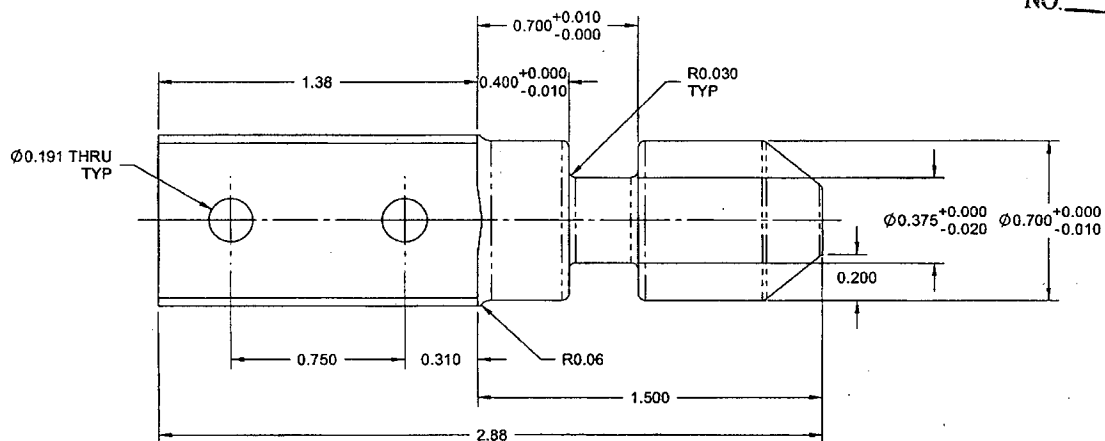


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NOTES:

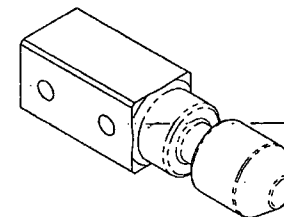
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

| | | | |
|------------|-----------------|---|--------------|
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| MFG. APPR. | | D4149 | SHEET 4 OF 5 |
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| DE APPR. | | AFT X-TUBE LUG ASSY | NTS |
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D4149-5 EYEBOLT STUD

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- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs

| | | | |
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